



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE105-14181W4-1

Job Sheet 200892



Part No: RBE105-14181W4-1

Job Qty: 10 pcs

Part Name: Shell



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/18/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 11/7/19

Description:

Note: DWG RBE105-14181W4 Rev.C IPP Rev. A 19.01.11 New issue DP Verify DD/IPP Rev. B 19.09.08 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	NLX 2500SY - 1	10		11/7/19	1.00	10.00	NLX 2500SY - 1		
	<i>DOSAN</i>	pcs					<i>DOSAN</i>		<i>De</i>
110	QC 2	10		11/7/19	0.00	0.00	QC 2 - 1		
	<i>45</i>	pcs							
	<i>9-89 19-10-25</i>								
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S228820



Part: RBE105-14181W4-1

Job No: 200892

Serial No/Batch: S228820

Revision: C

Inspector:

Exp Date:

Instructions:

Date: 10/31/19

DAS
45
9-89 19-10-25

112 QC8

Plex 9/18/19 1:41 PM Dart.lajeunesse.marie

					QC 2 - 65		
					QC 2 - 5		
					QC 2 - 71		
					QC 2 - 73		
					QC 2 - 69		
115 NV5000 - 1 - B4B	10 pcs	11/7/19	1.00 10.00		NV5000 - 1 - B4B	2/2/ALA	19-11-1
					NV5000 - 2 - B4B		
120 QC 2	10 pcs	11/7/19	0.00 0.00		QC 2 - 1		
					QC 2 - 12		
					QC 2 - 14	2/2/ALA	19-11-1
					QC 2 - 17		
					QC 2 - 19		
					QC 2 - 2		
					QC 2 - 20		
					QC 2 - 22		
					QC 2 - 23		
					QC 2 - 25		
					QC 2 - 32		
					QC 2 - 33		
					QC 2 - 35		
					QC 2 - 39		
					QC 2 - 4		
					QC 2 - 40		
					QC 2 - 44		
					QC 2 - 45		
					QC 2 - 48		
					QC 2 - 49		
					QC 2 - 50		
					QC 2 - 51		
					QC 2 - 52		
					QC 2 - 57		
					QC 2 - 62		
					QC 2 - 63		
					QC 2 - 8		
					QC 2 - 66		
					QC 2 - 64		
					QC 2 - 65		
					QC 2 - 5		
					QC 2 - 71		
					QC 2 - 73		
					QC 2 - 69		
125 QC 8	10 pcs	11/7/19	0.00 0.00		QC 8 - 12		
					QC 8 - 14		
					QC 8 - 17		
					QC 8 - 20		
					QC 8 - 25		
					QC 8 - 3		
					QC 8 - 32		
					QC 8 - 33		
					QC 8 - 35		
					QC 8 - 39		
					QC 8 - 4		
					QC 8 - 44		
					QC 8 - 45		
					QC 8 - 49		
					QC 8 - 58		
					QC 8 - 8	A-a 19-11-16	
					QC 8 - 9		
					QC 8 - 68		

						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
130	Outsource - 4 - Anodize	10 pcs	11/7/19			GRO002-VC	<i>2019-11-18</i>
140	Packaging 2-1 - Receive - B4B	10 pcs	11/7/19	0.00	0.00	Packaging 2 - 1 - B4B	
						Packaging 2 - 2 - B4B	
						Packaging 2 - 3 - B4B	
						Packaging 2 - 5 - B4B	<i>NOV 25 2019</i>
						Packaging 2 - 4 - B4B	
						Packaging 2 - 6 - B4B	
						Packaging 2 - 7 - B4B	
						Packaging 2 - 8 - B4B	
						Packaging 2 - 9 - B4B	
						Packaging 2 - 10 - B4B	
						Packaging 2 - 11 - B4B	
						Packaging 2 - 12 - B4B	
						Packaging 2 - 13 - B4B	
						Packaging 2 - 14 - B4B	
						Packaging 2 - 15 - B4B	
						Packaging 2 - 16 - B4B	
						Packaging 2 - 17 - B4B	
						Packaging 2 - 18 - B4B	
						Packaging 2 - 19 - B4B	
						Packaging 2 - 20 - B4B	
						Packaging 2 - 21 - B4B	
						Packaging 2 - 22 - B4B	
						Packaging 2 - 23 - B4B	
						Packaging 2 - 24 - B4B	
						Packaging 2 - 25 - B4B	
						Packaging 2 - 26 - B4B	
						Packaging 2 - 27 - B4B	
						Packaging 2 - 28 - B4B	
						Packaging 2 - 29 - B4B	
						Packaging 2 - 30 - B4B	
						Packaging 2 - 31 - B4B	

					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
150 QC 6	10 pcs	11/7/19	0.00	0.00	QC 6 - 9	DAS NOV 26 2019 68 9-89
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
160 Packaging 3-1 - Stock - B4B	10 pcs	11/7/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	DAS 23 2-00
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	

				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	10 pcs	11/7/19	0.00 0.00	QC 21 - SA - 21	DAS 21
				QC 21 - SA - 70	9-88

Part Op 100 - 1-Machine as per DWG. 2-Debur
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 115 - ***Cut part in half on band saw*** 1-Machine as per folio 5054
 2-Debur
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 125 - (QC8- Inspect parts - second check)
 130 - (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O: 45130 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required
 140 - (Receive & Inspect for Damage & Mat'l Certs) Certificate of Conformity is required
 150 - QC6- All purchased or subcontracted products
 160 - Identify as per dwg & Stock Location:
 170 - QC21- Final Inspection - Work Order Release

FOLIO REV: AA DWG REV:

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6R6.000	Round Bar 6.00"	9 ft (.9 ea)	100-NLX 2500SY - 1	5126177

48ft 466 45 209-10-25

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-NLX 2500SY - 1	M6061T6R6.000	9	10	0

Part Specifications	
Specifications could not be found.	

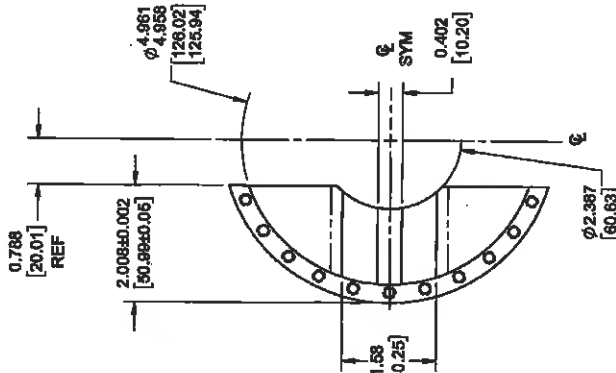
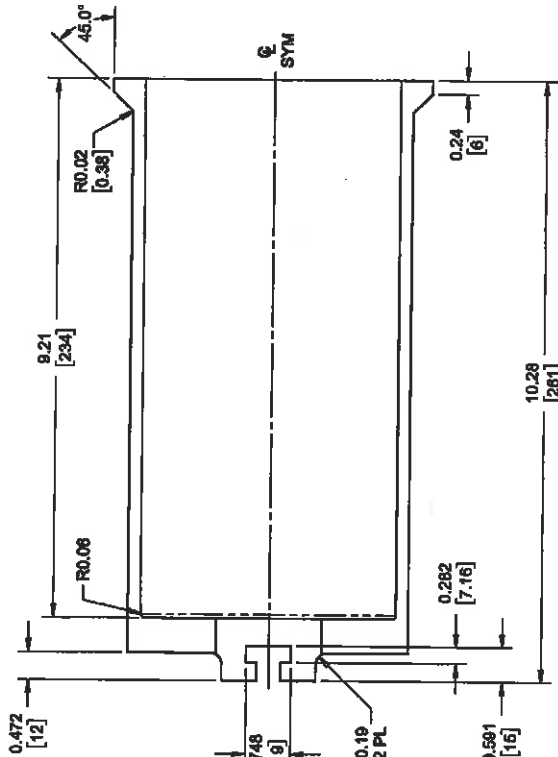
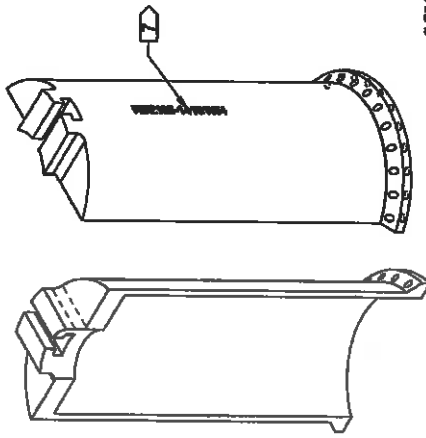
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Job BOM 466

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 200892145 19-11-14



RBE105-14181W4-1 SHELL

- NOTES:
- 1) MATERIAL: 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE RED PER MIL-A-8825 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK TAIL, "RBE105-14181W4", AS SHOWN

DESIGN	VM	DATE	2019-11-14
DRAWN	VM		
CHECKED	KPT		
MFG. APPR.	APR		
APPROVED	APR		
DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA TOOL PART # RBE105-14181W4 REV. C SHEET 2 OF 8			
NEEDLE BEARINGS EXTRACTOR SCALE N/A MFG. PART # RBE105-14181W4			
DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA 1000 DART AEROSPACE DRIVE HAWKSBURY, ONTARIO L0R 1A0 TEL: (905) 881-1111 WWW.DARTAEROSPACE.COM			

Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Machining ☐ Small Fab ☐ Large Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		MRB (QS1042)																													
Date : _____		Sequence #: _____		QTY Affected : _____		Disposition																													
Description Work Order Deviation				Completed By																															
_____				Lead hand / Supervisor																															
_____				QC / QA Coordinator																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																																
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Other/Details:		_____																																	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB045130



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

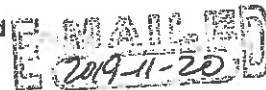
Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045130
PO Date: 11/18/19
Due Date: 11/26/19
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 60

Freight Terms:
Special Comments:



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	200892	RBE105-14181W4-1	RBE105-14181W4 Rev C	Shell (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed X10	-	11/26/19	10 pcs	0 pcs	10 pcs	\$13.85/pcs	\$138.50

NOV 25 2019

68
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045130



Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	201262	RB T103296-101-1	RB T103296-101 Rev A	Collar Half 1 -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed <i>xl6</i>	-	11/26/19	6 pcs	0 pcs	6 pcs	\$1.18/pcs	\$7.08
											NOV 21 2019	
3	201263	RB T103296-101-2	RB T103296-101 Rev A	Collar Half 2 -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed <i>xl6</i>	-	11/26/19	6 pcs	0 pcs	6 pcs	\$1.18/pcs	\$7.08
											NOV 21 2019	
											Grand Total:	\$152.66

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an Integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/20/19 8:52 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(024205-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupepaltech.com

Bon de Livraison / Packing Slip

024205- 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date	Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
22-Nov-2019	Jigar Patel		POHB045130					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
1	RBE105-14181W4-1 Rev.C	RBE105-14181W4 ANO-RED (ANODIZE RED) AS PER JAW MIL-A-8625F TYPE - 2, CLASS - 2 WATER SEALANT	ANODIZE CH	10	10	0	0	0

DAS
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9-89

RECEIVED
NOV 22 2019
DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes:

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.